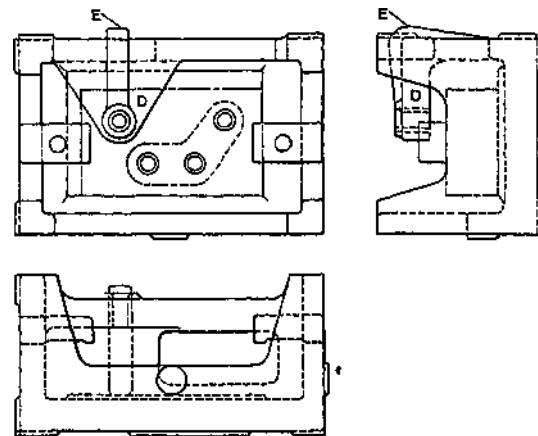


part *D*, Fig. 10, is strengthened, when necessary, by a rib *E*, as indicated. Care must be taken that there is sufficient clearance for the piece to be inserted and removed. Once in a while it happens, even with fairly good jig designers, that an otherwise well-designed jig with good locating, clamping, and guiding arrangements, is rendered useless, for the simple reason that there is not enough clearance to allow the insertion of the work.

Fig. ii shows the same jig as before, but with the additional feature of permitting a hole in the work to be drilled from the end and side as indicated, the bushings *E* and *F* being added



**Fig. 10. Modification of
Jig Shown in Fig. 9**

for this purpose. The bushings, in this case, extend through the jig wall for some distance, in order to guide the drill closely to the work. Bosses may also be cast on the jig body, as indicated by the dotted lines,

to give a longer bearing for the bushings.

Feet or lugs are cast and finished on the sides of the jig opposite the bushings, so that the jig can be placed conveniently on the drill-press table for drilling in any direction. When drilling the holes from the bushings *E* and *F*, the thrust is taken by the stationary locating pins. It is objectionable to use set-screws to take the thrust, although in some cases it is necessary to do so. When designing a jig of this type, care must be taken that strapping arrangements and locating points are placed so that